



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

Tel (613) 632-5200

D350-591-311
Job Sheet 176869



Part No: D350-591-311

Job Qty: 10 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/2/18

Job Tracking No:

Due Date: 6/6/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in born DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		6/6/18	0.00	0.00	Start Up Large Fab-4		CPC
110	Large Fab	10 pcs		6/6/18	0.00	9.91	Large Fab 2		CPC
120	QC	10 pcs		6/6/18	0.00	0.00	QC9		PD 18-05-17
130	QC	10 pcs		6/6/18	0.00	0.00	QC5		PD 18-05-17
140	HandFinish	10 pcs		6/6/18	0.00	1.84	HandFinish1		SA 18-05-23
150	QC	10 pcs		6/6/18	0.00	0.00	QC7-2		CPC
180	Large Fab	10 pcs		6/6/18	0.00	9.91	Large Fab 2		SLH
190	QC	10 pcs		6/6/18	0.00	0.00	QC10		CPC
200	QC	10 pcs		6/6/18	0.00	0.00	QC5		CPC
210	HandFinish	10 pcs		6/6/18	0.00	1.84	HandFinish1		BED 18-05-29
220	Powdercoat	10 pcs		6/6/18	0.00	2.90	Powdercoat1		BE 18-5-30
230	HandFinish	10 pcs		6/6/18	0.00	1.84	HandFinish3		BE 18-05-30
240	QC	10 pcs		6/6/18	0.00	0.00	QC3		38
250	Packaging	10 pcs		6/6/18	0.00	0.00	Packaging1-3		9-89
260	QC	10 pcs		6/6/18	0.00	0.00	QC4		J.R.B. DAS
265	DC	10 pcs		6/6/18	0.00	0.00	DC		J.R.B. 28
270	Packaging	10 pcs		6/6/18	0.00	0.00	Packaging3-1		DAS 18-05-30
280	QC21-FG	10 Ea		6/6/18	0.00	0.00	QC21		21 MAY 31 2018 28

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod M134 F85 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod _____ 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 1:45 OVEN TEMPERATURE: 350 FINISH TIME: 2:15

265 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

5072165x10xLH



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Container No: S072165



Part: D350-591-311

Job No: 176869

Serial No/Batch: S072165

Revision:

Inspector:

Date: 05/17/18

35
28-3

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 Ea (2 ea)	90-Start up Operation	5066631
D3219-1	Plate	20 Ea (2 ea)	90-Start up Operation	3068282
D3272-1	Step	10 Ea (1 ea)	90-Start up Operation	5070350
D3065-041	Step Leg Assembly	10 Ea (1 ea)	180-Large Fab	50737566
D3066-1	Spacer	20 Ea (2 ea)	180-Large Fab	5066698
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab	504171
AN3-35A	Bolt	20 Ea (2 ea)	250-Packaging	
AN4-13A	Bolt	80 Ea (8 ea)	250-Packaging	
AN5-36A	Bolt	20 Ea (2 ea)	250-Packaging	
D2230-3	Mounting Lug	40 Ea (4 ea)	250-Packaging	
D2618	Bushing	20 Ea (2 ea)	250-Packaging	
D2856-400-720	Abrasion Strip 4" X 7.20"	20 Ea (2 ea)	250-Packaging	
D3235-1	Mounting Lug	20 Ea (2 ea)	250-Packaging	
D3278-041	Support Assembly	10 Ea (1 ea)	250-Packaging	
MS21042L3	Nut	20 Ea (2 ea)	250-Packaging	
MS21042L4	Nut	80 Ea (8 ea)	250-Packaging	
MS21042L5	Nut	20 Ea (2 ea)	250-Packaging	
NAS1149D0363J	Washer	40 Ea (4 ea)	250-Packaging	
NAS1149D0463J	Washer	160 Ea (16 ea)	250-Packaging	
NAS1149D0563J	Washer	40 Ea (4 ea)	250-Packaging	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	20	47	0
	D3219-1	20	21	0
	D3272-1	10	0	0
180-Large Fab	D3065-041	10	2	0
	D3066-1	20	61	0
	MS20600-AD4W4	160	1,003	0
250-Packaging	AN3-35A	20	188	0
	AN4-13A	80	1,051	0
	AN5-36A	20	148	0
	D2230-3	40	190	0
	D2618	20	327	0
	D2856-400-720	20	65	0
	D3235-1	20	176	0
	D3278-041	10	6	0
	MS21042L3	20	1,992	0
	MS21042L4	80	2,822	0
	MS21042L5	20	874	0
	NAS1149D0363J	40	2,242	0
	NAS1149D0463J	160	5,479	0
	NAS1149D0563J	40	1,451	0

Part Specifications

Specifications could not be found.

Plex 5/2/18 11:49 AM Dart.Gagnon.Michelle



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
003547	S047324	AN3-35A	Bolt		ST348	6
003547	S076605	AN3-35A	Bolt	s047337	ST348	14
003547	S076602	AN4-13A	Bolt	s062374	ST344	80
003547	S076601	AN5-36A	Bolt	s048292	ST336	20
003547	S076539	D2230-3	Mounting Lug	s065889	ST521	40
003547	S076600	D2618	Bushing	s049859	ST008	20
003547	S076599	D2856-400-720	Abrasion Strip 4" X 7.20"	S068921	ST418	20
003547	S076540	D3235-1	Mounting Lug	s053650	ST522	20
003547	S067940	D3278-041	Support Assembly	S066185	ST522	6
003547	S076686	D3278-041	Support Assembly	S076754	ST522	4
003547	S076598	MS21042L3	Nut	S075328	ST303	20
003547	S076597	MS21042L4	Nut	S056039	ST303	80
003547	S076596	MS21042L5	Nut	S041167	ST303	20
003547	S076498	NAS1149D0363J	Washer	S015269	ST263	40
003547	S076497	NAS1149D0463J	Washer	S055952	ST263	160
003547	S076496	NAS1149D0563J	Washer	S039036	ST263	40

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

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REFERENCE ONLY

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.